

Date: Tuesday, 27/05/2008 9:07:09 AM
 User: Linda Lacelle

Process Sheet

*split into
83 08/06/09*

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 39504-2
 Estimate Number : 10505
 P.O. Number :
 This Issue : 27/05/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : / / Type : SMALL / MED FAB
 Previous Run : 38795
 Written By :
 Checked & Approved By :
 Comment : Est : F 02.08.21 Re-format; Added D2057 KJ/RF
 Est Rev:G 08-05-27 as per ECN1195P DD verified by:EC

Drawing Name : MIRROR ARM

Part Number : D2010103
 Drawing Number : D2010 PRELIM
 Project Number : N/A
 Drawing Revision : PRELIM 08.05.30
 Material :
 Due Date : 03/06/2008 Qty: -20 Um: Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description:
1.0	M304TR0500W049	304 RD Tube .500 x .049W



Comment: Qty.: 1.5750 f(s)/Unit Total: 31.5000 f(s) ~~049~~ 06.05.30 M108215
 Material: 304/316 SS tubing 0.500" Dia. x ~~0.049"~~ wall (M304TR0500W049) Batch No: M107518 (14) SB 03/06/02



2.0	BRAKE NC	NC BRAKE
-----	----------	----------



Comment: BRAKE NC

Punch per Dwg. D2010-103-T1 and Spec Control Dwg D2727
 Identify as D2010-103

SB 08/06/02 (

3.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
-----	-------------	-------------------------------



Comment: SMALL & MEDIUM FAB RESOURCE 1

1- Bend as per Dwg D2010 using bending Jig D2010-103T2
 2- Deburr ends

Plug



4.0	D2057	Plug
-----	-------	------



Comment: Qty.: 1.0000 Each(s)/Unit Total: 20.0000 Each(s)

Plug

Pick:

Qty	Part Number	Description	Batch
1	D2057	Plug	39661

D2057



FF 08-06-09



Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MIRROR ARM

Job Number: 39504

Part Number: D2010103

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0 SMALL FAB 1



SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-flare before installing plug as per dwg D2010

2-Install D2057 plug as per Dwg D2010

FF 08-06-12 (6)

6.0 QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/06/12 (6)

7.0 POWDER COATING



POWDER COATING

M 10 2 3 1 6



(6X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

10 - 40 μm

START TIME:

OVEN TEMPERATURE:

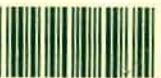
FINISH TIME:

320 $^{\circ}\text{C}$

11-20 μm

m-f 08/06/12

8.0 QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION

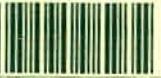


(6)

Comment: INSPECT POWDER COAT

FZ 08/06/12

9.0 PACKAGING 1



PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

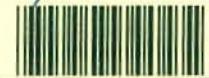
ST228

R 08/06/13 (6)

10.0 QC21



FINAL INSPECTION/W/O RELEASE



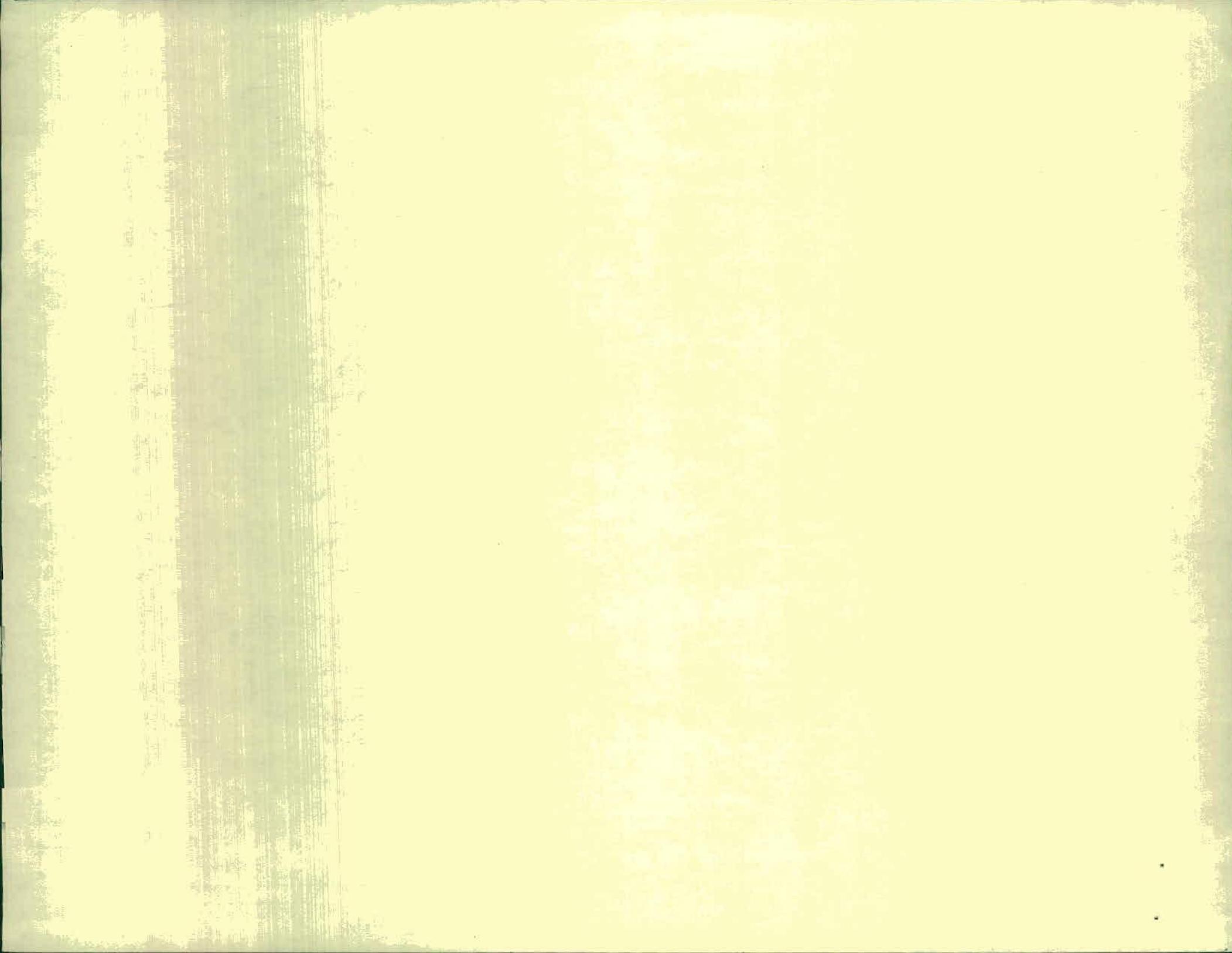
08/06/16 (6)

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



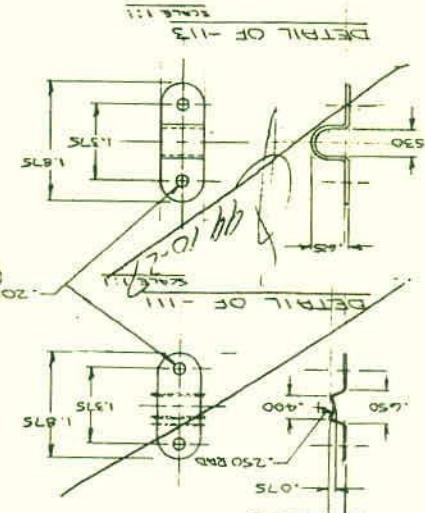
L 08.06.16



4	EE-032-EF	RASTERBZ	PEN	D 2010-113	CLAMP	.050 THICK	TEST 304	D 2010-109	PLUG	.606-1.6	EFR	00-A-225/C
5				D 2010-111	SPRING	.025THICK	TEST 304	D 2010-105				
6				D 2010-103	PRM	CABLE TUBE .50MM X .054MM	TEST 304	D 2010-101	RETRACT	2024-T3	Q53741	A3-A-254/B
7				D 2010-102				D 2010-101				
8				D 2010-104				D 2010-105				
9				D 2010-106				D 2010-107				
10				D 2010-108				D 2010-109				
11				D 2010-110				D 2010-111				
12				D 2010-112				D 2010-113				
13				D 2010-114				D 2010-115				
14				D 2010-116				D 2010-117				
15				D 2010-118				D 2010-119				
16				D 2010-120				D 2010-121				
17				D 2010-122				D 2010-123				
18				D 2010-124				D 2010-125				
19				D 2010-126				D 2010-127				
20				D 2010-128				D 2010-129				
21				D 2010-130				D 2010-131				
22				D 2010-132				D 2010-133				
23				D 2010-134				D 2010-135				
24				D 2010-136				D 2010-137				
25				D 2010-138				D 2010-139				
26				D 2010-140				D 2010-141				
27				D 2010-142				D 2010-143				
28				D 2010-144				D 2010-145				
29				D 2010-146				D 2010-147				
30				D 2010-148				D 2010-149				
31				D 2010-150				D 2010-151				
32				D 2010-152				D 2010-153				
33				D 2010-154				D 2010-155				
34				D 2010-156				D 2010-157				
35				D 2010-158				D 2010-159				
36				D 2010-160				D 2010-161				
37				D 2010-162				D 2010-163				
38				D 2010-164				D 2010-165				
39				D 2010-166				D 2010-167				
40				D 2010-168				D 2010-169				
41				D 2010-170				D 2010-171				
42				D 2010-172				D 2010-173				
43				D 2010-174				D 2010-175				
44				D 2010-176				D 2010-177				
45				D 2010-178				D 2010-179				
46				D 2010-180				D 2010-181				
47				D 2010-182				D 2010-183				
48				D 2010-184				D 2010-185				
49				D 2010-186				D 2010-187				
50				D 2010-188				D 2010-189				
51				D 2010-190				D 2010-191				
52				D 2010-192				D 2010-193				
53				D 2010-194				D 2010-195				
54				D 2010-196				D 2010-197				
55				D 2010-198				D 2010-199				
56				D 2010-200				D 2010-201				
57				D 2010-202				D 2010-203				
58				D 2010-204				D 2010-205				
59				D 2010-206				D 2010-207				
60				D 2010-208				D 2010-209				
61				D 2010-210				D 2010-211				
62				D 2010-212				D 2010-213				
63				D 2010-214				D 2010-215				
64				D 2010-216				D 2010-217				
65				D 2010-218				D 2010-219				
66				D 2010-220				D 2010-221				
67				D 2010-222				D 2010-223				
68				D 2010-224				D 2010-225				
69				D 2010-226				D 2010-227				
70				D 2010-228				D 2010-229				
71				D 2010-230				D 2010-231				
72				D 2010-232				D 2010-233				
73				D 2010-234				D 2010-235				
74				D 2010-236				D 2010-237				
75				D 2010-238				D 2010-239				
76				D 2010-240				D 2010-241				
77				D 2010-242				D 2010-243				
78				D 2010-244				D 2010-245				
79				D 2010-246				D 2010-247				
80				D 2010-248				D 2010-249				
81				D 2010-250				D 2010-251				
82				D 2010-252				D 2010-253				
83				D 2010-254				D 2010-255				
84				D 2010-256				D 2010-257				
85				D 2010-258				D 2010-259				
86				D 2010-260				D 2010-261				
87				D 2010-262				D 2010-263				
88				D 2010-264				D 2010-265				
89				D 2010-266				D 2010-267				
90				D 2010-268				D 2010-269				
91				D 2010-270				D 2010-271				
92				D 2010-272				D 2010-273				
93				D 2010-274				D 2010-275				
94				D 2010-276				D 2010-277				
95				D 2010-278				D 2010-279				
96				D 2010-280				D 2010-281				
97				D 2010-282				D 2010-283				
98				D 2010-284				D 2010-285				
99				D 2010-286				D 2010-287				
100				D 2010-288				D 2010-289				
101				D 2010-290				D 2010-291				
102				D 2010-292				D 2010-293				
103				D 2010-294				D 2010-295				
104				D 2010-296				D 2010-297				
105				D 2010-298				D 2010-299				
106				D 2010-300				D 2010-301				
107				D 2010-302				D 2010-303				
108				D 2010-304				D 2010-305				
109				D 2010-306				D 2010-307				
110				D 2010-308				D 2010-309				
111				D 2010-310				D 2010-311				
112				D 2010-312				D 2010-313				
113				D 2010-314				D 2010-315				
114				D 2010-316				D 2010-317				
115				D 2010-318				D 2010-319				
116				D 2010-320				D 2010-321				
117				D 2010-322				D 2010-323				
118				D 2010-324				D 2010-325				
119				D 2010-326				D 2010-327				
120				D 2010-328				D 2010-329				
121				D 2010-330				D 2010-331				
122				D 2010-332				D 2010-333				
123				D 2010-334				D 2010-335				
124				D 2010-336				D 2010-337				
125				D 2010-338				D 2010-339				
126				D 2010-340				D 2010-341				
127				D 2010-342				D 2010-343				
128				D 2010-344				D 2010-345				
129				D 2010-346				D 2010-347				
130				D 2010-348				D 2010-349				
131				D 2010-350				D 2010-351				
132				D 2010-352				D 2010-353				
133				D 2010-354				D 2010-355				
134				D 2010-356				D 2010-357				
135				D 2010-358				D 2010-359				
136				D 2010-360				D 2010-361				
137				D 2010-362				D 2010-363				
138				D 2010-364				D 2010-365				
139				D 2010-366				D 2010-367				
140				D 2010-368				D 2010-369				
141				D 2010-370				D 2010-371				
142				D 2010-372				D 2010-373				
143				D 2010-374				D 2010-375				
144				D 2010-376				D 2010-377				
145				D 2010-378				D 2010-379				
146				D 2010-380				D 2010-381				
147				D 2010-382				D 2010-383				
148				D 2010-384				D 2010-385				
149				D 2010-386				D 2010-387				
150				D 2010-388				D 2010-389				
151				D 2010-390				D 2010-391				
152				D 2010-392				D 2010-393				
153				D 2010-394				D 2010-395				
154	</td											

RELEASED
04-02-03

1031-1049 TO HAVE D. D. W. M. H.
08-05 A.M. 1968



DETAIL OF -103

SLOT WIDTH: .0645

103-103-103

4-12-68

103-103-103

.335 ± .005 O.D.

.0645

.125

.625

GENERAL NOTE 5:

卷二

בראכג

(54-42-5)

ALLERTION

1-9104. 8

DRIVER'S LICENSE		TICKET NUMBER			
PERIOD	DRIVER'S LICENSE	DRIVER'S LICENSE	TICKET NUMBER	AMOUNT	

BOAELLE NO. 0121

AMENDMENT

